

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002513**Date Inspected:** 30-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b> Yes No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b> Yes No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b> Yes No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b> Yes No N/A
				<b>Delayed / Cancelled:</b> Yes No N/A

**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Tower Bay 1 & 2: QA Inspector performed 10% minimum visual and magnetic particle inspections of portions of QC acceptable inspection on Skin Plates ESD1 SA216B K7A, ESD1 SA216A K17A, ESD1 SA227A H17A, ESD1 SA227A H14A, and SSD1 SA16 F/G welds 1, 3, 5, 7, 8, 109, 110, and 112 from side "A" Complete Joint Penetration (CJP) butt welds. welds. QA Inspector found QC MT accepted welds to be in compliance with AWS D1.5 (02) and the contract documents. For details please see Magnetic particle testing report TL-6028 dated April 30, 2008

Tower Bay 1: QA Inspector performed ultrasonic verification testing of skin plate Complete Joint Penetration (CJP) butt joint after ZPMC QC UT acceptance. QA Inspector UT tested plate ESD1 SA227A H14A side "A". QA Ultrasonic Testing (UT) was performed to verify that a minimum of 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60 #01RN5T. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 and 45 degree angle wedges from face A. For details please see the ultrasonic testing report TL-6027 dated April 30, 2008. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

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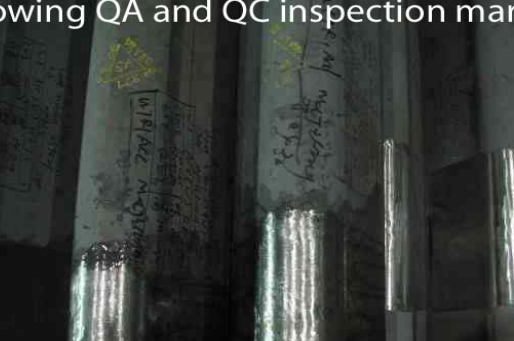
Skin Plate ESD1 SA227 A/H 14A showing QA and QC acceptance marks

WPS	07/11/05	08.428.1639
WPS	WPS-B-1-2221-17-03c-5	WPS-B-1-2221-17-03c-5
VT	Ace	Final Inspection
VT	REJ	REWORKING
MT		08.428.1639

For WT o/c  
20/11/05  
- 6.45

1653 043008

DP113-001-155 and DP113-001-156  
showing QA and QC inspection marks



1853 043008

<b>Inspected By:</b>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer